



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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Report

D4936-1

Job Sheet 180081



Part No: D4936-1

Job Qty: 20 ea

Part Name: Clamp



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/28/18

Job Tracking No:

Due Date: 7/20/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP REV:A NEW ISSUE 13-10-21 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea	7/20/18	7/20/18	0.00	0.00	Start Up Machining-3		DJP
100	Mill Conv	20 pcs	7/20/18	7/20/18	0.00	6.37	Mill Conv 1		DJP
120	QC	20 pcs	7/20/18	7/20/18	0.00	0.00	QC8		9-18/07/31
130	HandFinish	20 pcs	7/20/18	7/20/18	0.00	0.60	HandFinish1		SA 18-07-31
140	QC	20 pcs	7/20/18	7/20/18	0.00	0.00	QC7-4		18-08-01
150	Powdercoat	20 pcs	7/20/18	7/20/18	0.00	0.31	Powdercoat4		18-08-01
160	QC	20 pcs	7/20/18	7/20/18	0.00	0.00	QC3		
170	Packaging	20 pcs	7/20/18	7/20/18	0.00	0.00	Packaging3-2	5/128	
180	QC21-SA	20 Ea	7/20/18	7/20/18	0.00	0.00	QC21		AUG 02 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.375X0.750	6061T6 Bar .375 X .750	3 ft (.15 ea)	90-Start up Operation	FM 137599-80

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B0.375X0.750	3	6	0



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CANADA
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www.dartaerospace.com

Container No: S097601



Part: D4936-1

Job No: 180081

Serial No/Batch: S097601

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 07/30/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Clamp	0.750Inches $\pm$ 0.030	0.780 0.720	0.755	
2	Clamp	0.380Inches $\pm$ 0.030	0.410 0.350	0.375	
3	Clamp	1.800Inches $\pm$ 0.030	1.830 1.770	1.800	
4	Clamp	0.210Inches $\pm$ 0.030	0.240 0.180	0.210	
5	Clamp	1.375Inches $\pm$ 0.010	1.385 1.365	1.375	
6	Clamp	0.203Inches + 0.005 - 0.001	0.208 0.202	0.204	Diameter
7	Clamp	0.900Inches $\pm$ 0.030	0.930 0.870	0.900	
8	Clamp	0.030Inches $\pm$ 0.010	0.040 0.020	0.030	
9	Clamp	0.250Inches $\pm$ 0.030	0.280 0.220	0.250	Radius
10	Clamp	0.060Inches $\pm$ 0.030	0.090 0.030	0.060	Radius

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Plex 7/26/18 11:57 AM dart.lacelle.linda

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							